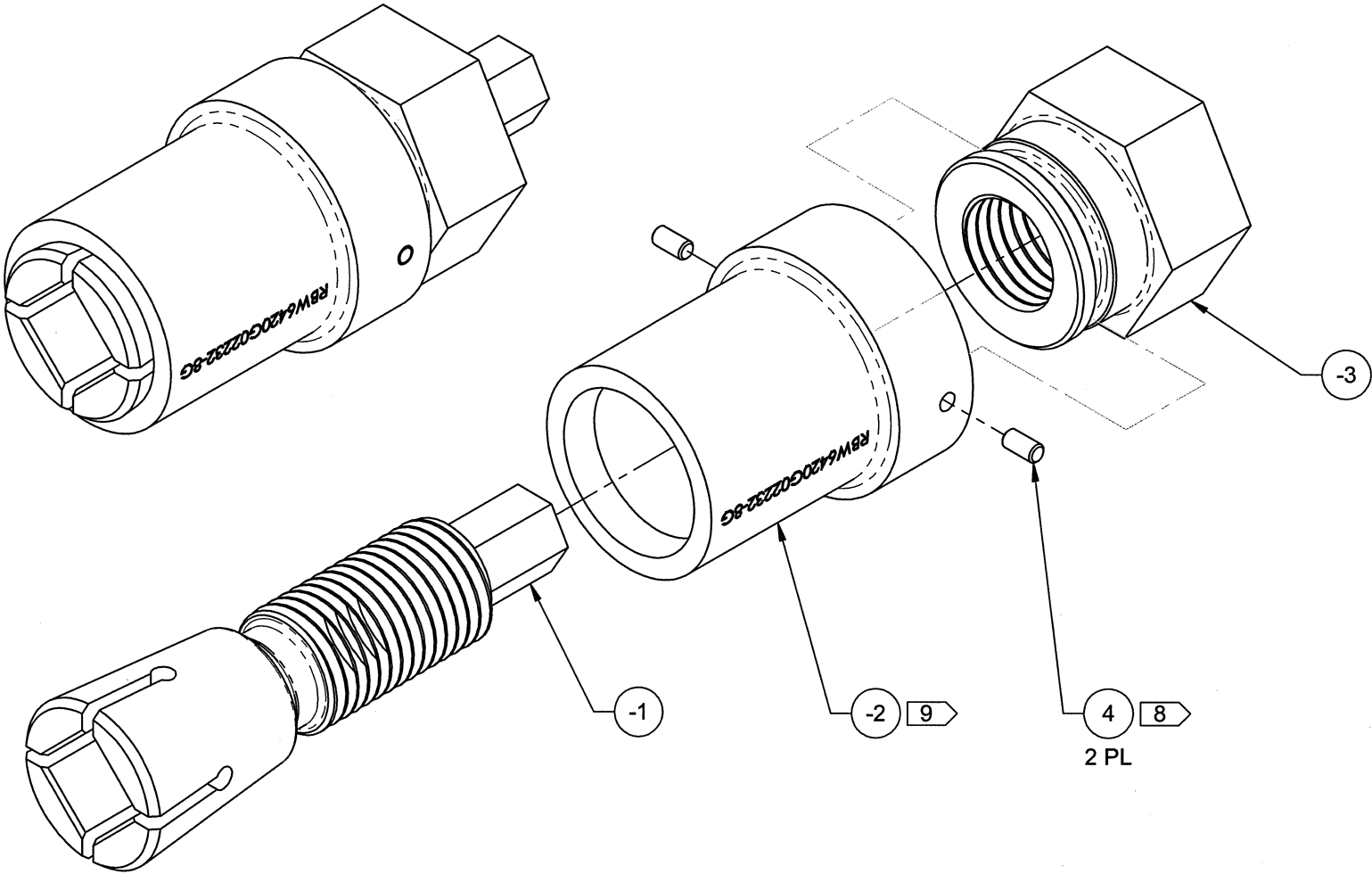
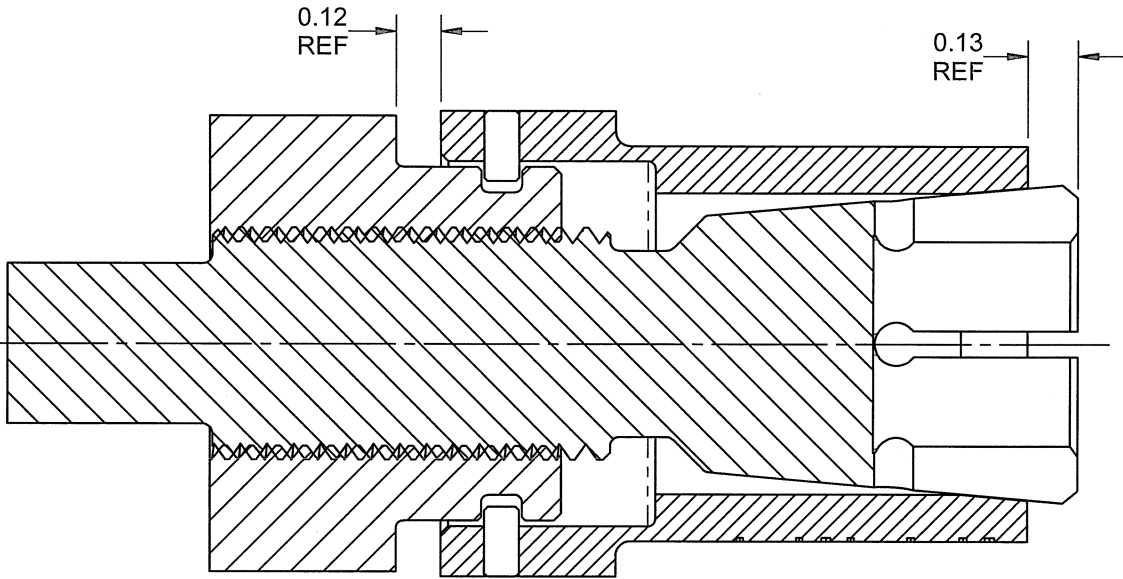
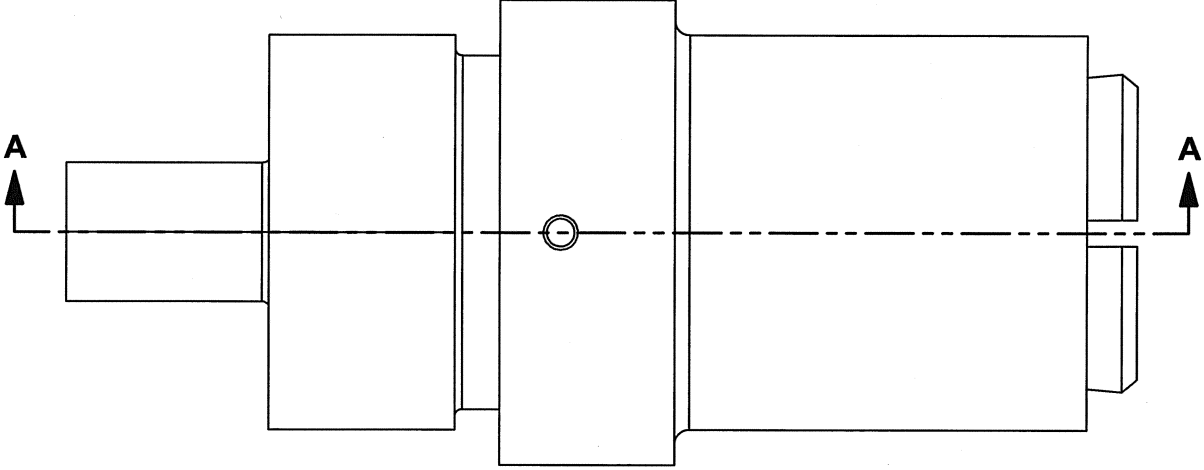


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6420G02232-8G-1	REACTION
-2	1	RBW6420G02232-8G-2	SLIDER
-3	1	RBW6420G02232-8G-3	NUT
4	2	McMaster#98380A433 OR EQUIV.	416 SS DOWEL PIN 3/32" DIA. X 3/16" LG.



RBW6420G02232-8G T/R SPIDER AND SLIDER REACTION TOOL

10

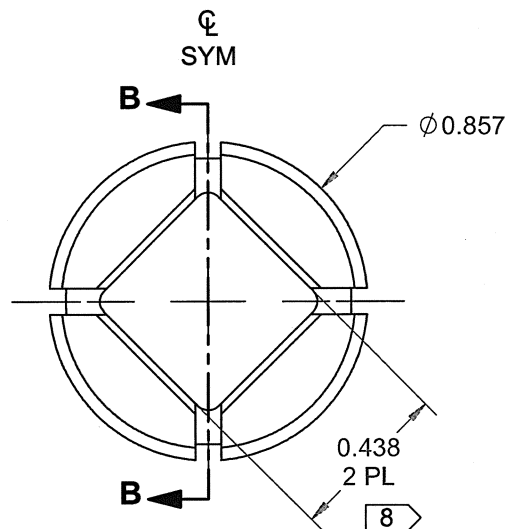


SECTION A-A

- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) ASSEMBLE AS SHOWN
  - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES  
THEN PRESS FIT ITEM 4 FLUSH TO SURFACE OF ITEM -2, AND REMOVE EXCESS
  - 9) ITEM -2 MUST ROTATE FREELY
  - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

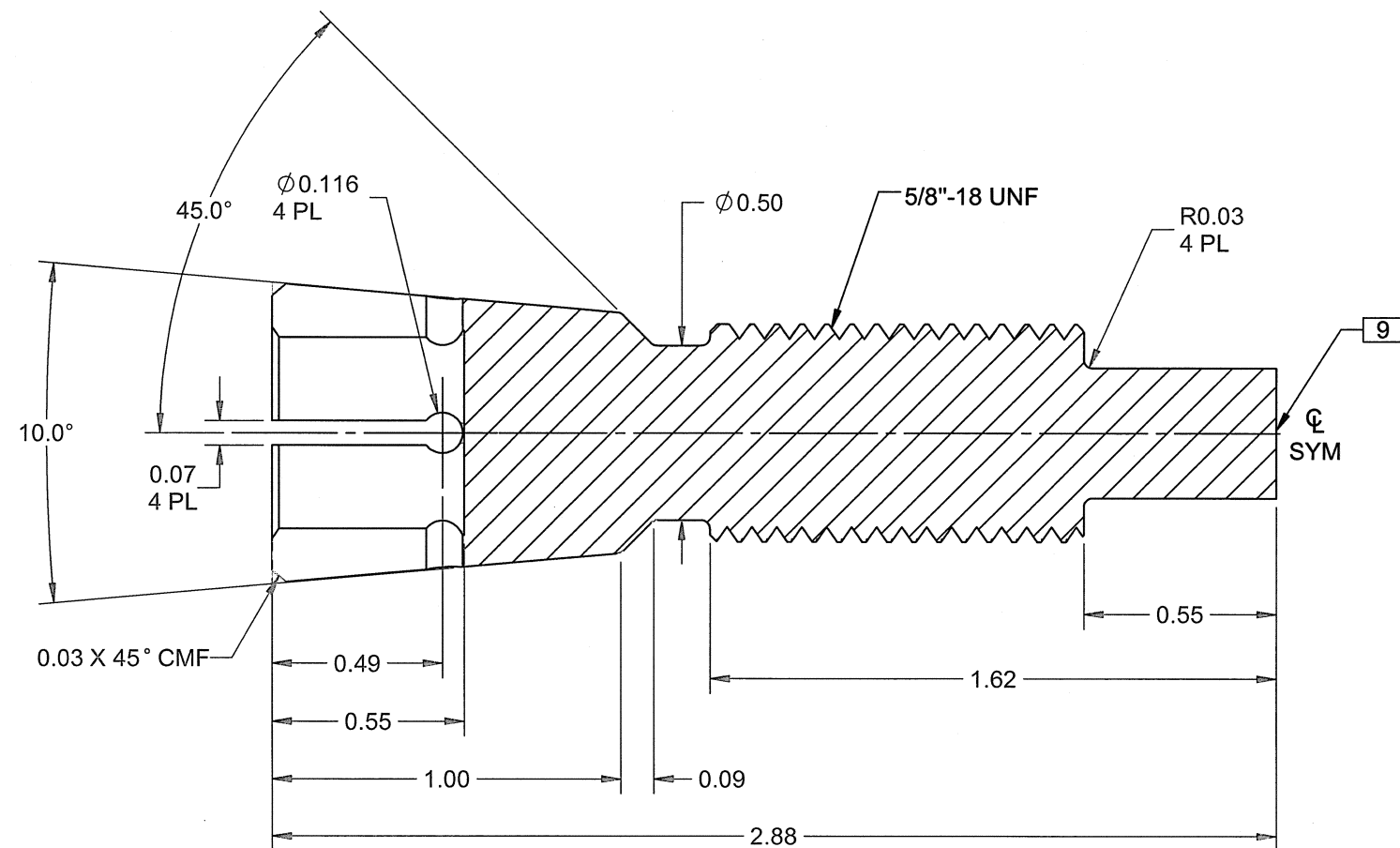
A	NEW ISSUE	19-712	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	RBW6420G02232-8G	SHEET 1 OF 4
APPROVED		TITLE	SCALE
		T/R SPIDER AND SLIDER REACTION TOOL	NTS
DATE	5/1/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

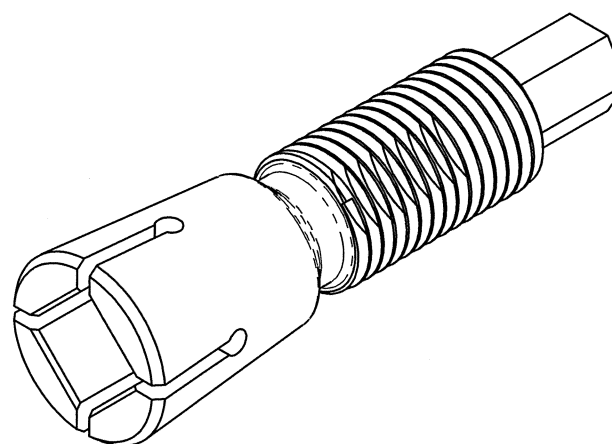
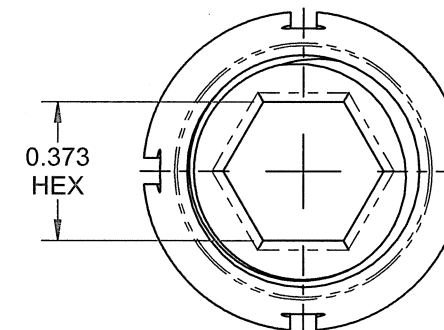


**RBW6420G02232-8G-1 REACTION**

10





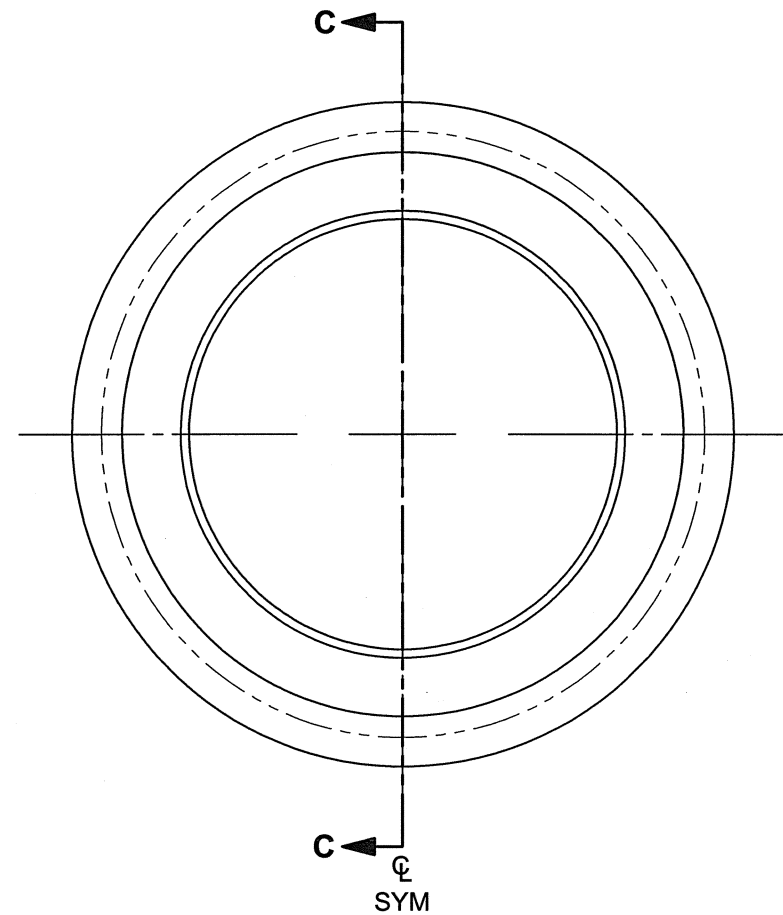
**SECTION B-B**



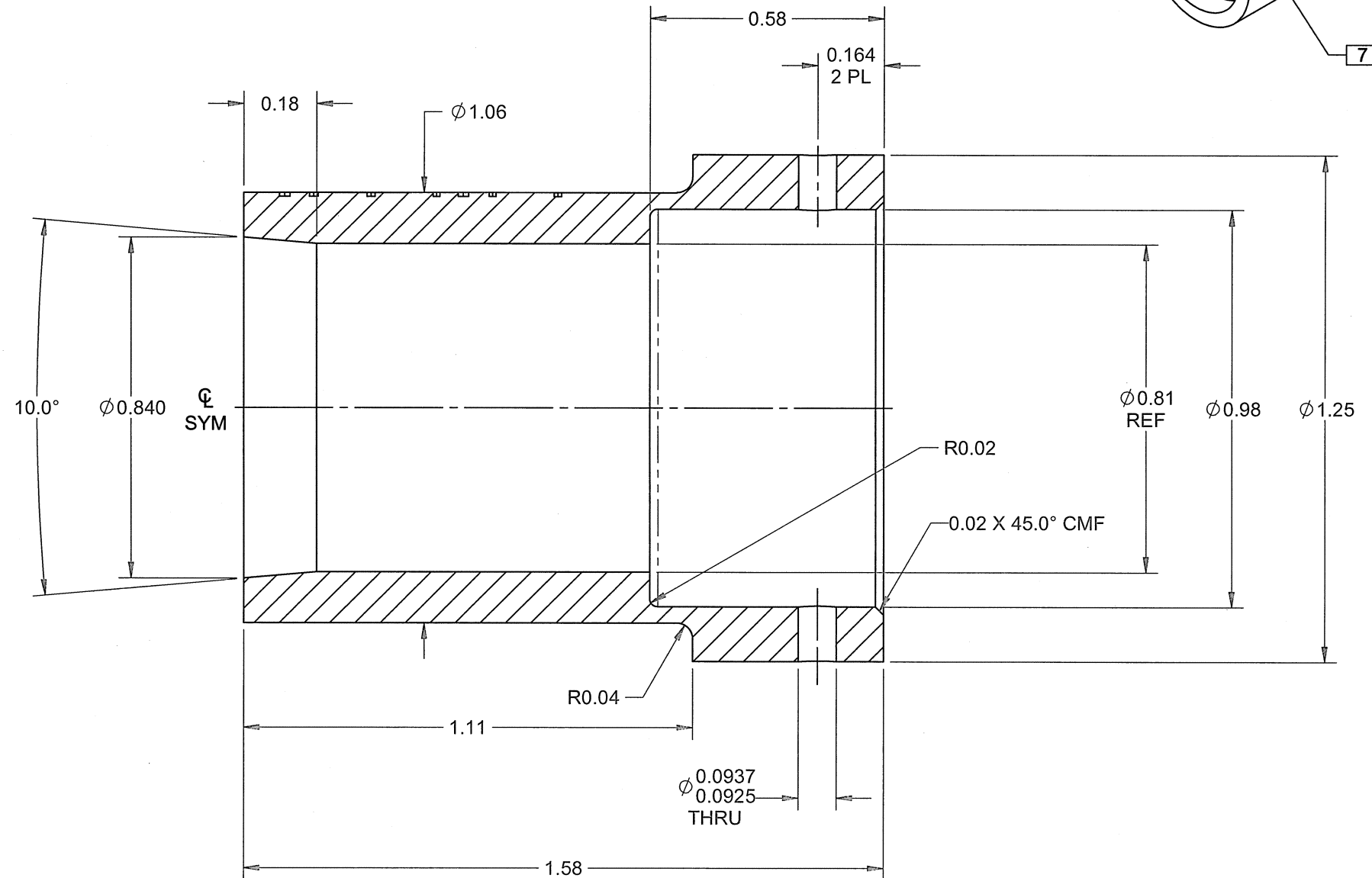
**NOTES:**

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: 40-45 Rc
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) BROACH CORNERS CAN BE RELIEVED WITH 1/16" DRILL DIA. IF NECESSARY
- 9) CENTER DRILL IS ACCEPTABLE
- 10) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RBW6420G02232-8G-1 REV. A.STEP

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV.
MFG. APPR.	JFG	RBW6420G02232-8G	SHEET 2 OF
APPROVED		TITLE	SCALE
		T/R SPIDER AND SLIDER REACTION TOOL	NTS 
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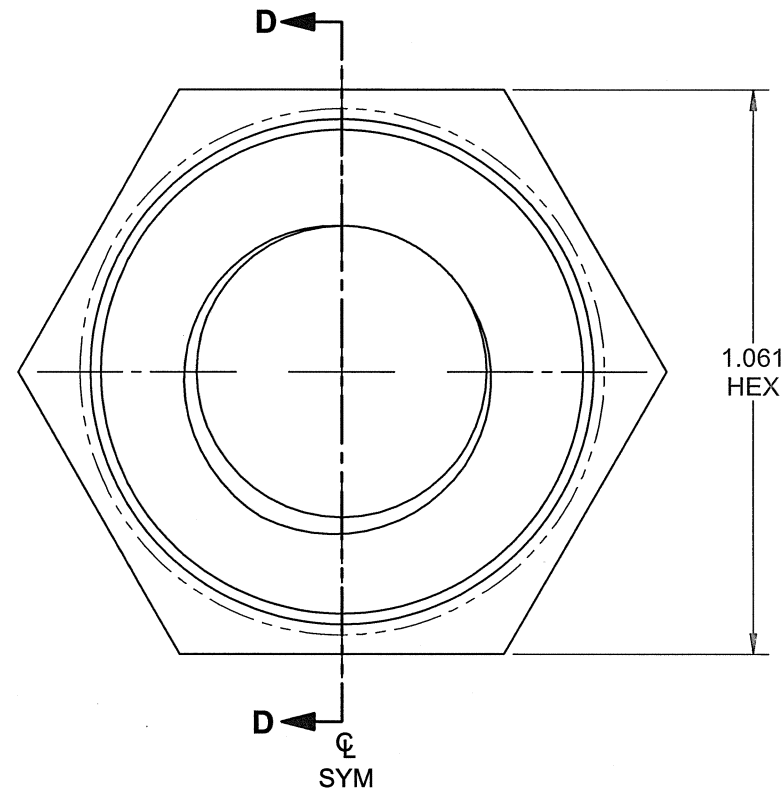
**RBW6420G02232-8G-2 SLIDER**



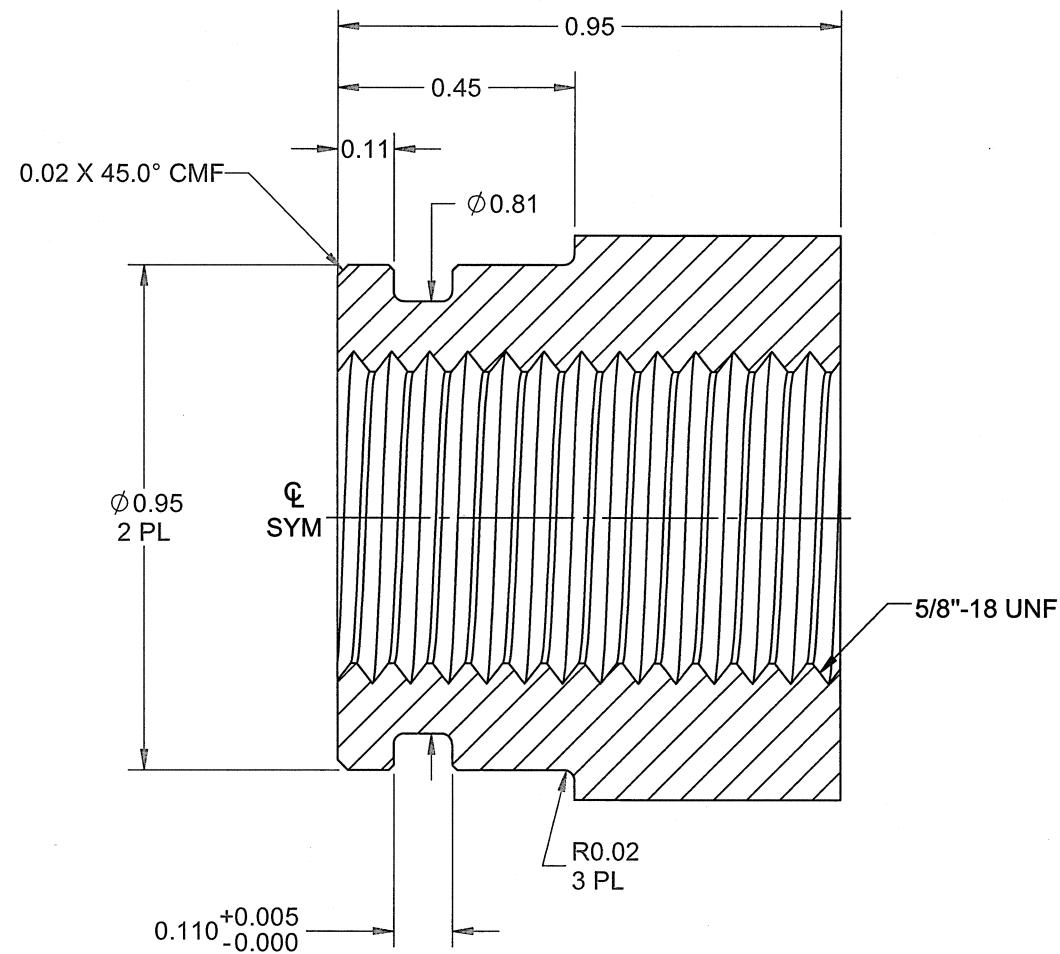
**SECTION C-C**

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
  - 2) HEAT TREAT: 40-45 Rc
  - 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES AND BURRS
  - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

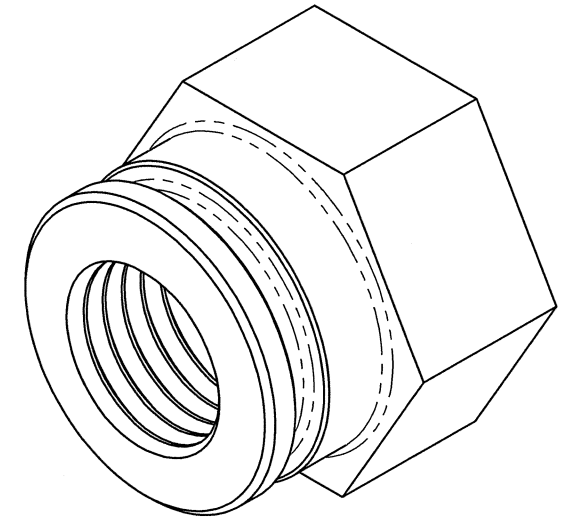
DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	<b>RBW6420G02232-8G</b>	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DATE	5/1/2019	T/R SPIDER AND SLIDER REACTION TOOL	NTS
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
**RBW6420G02232-8G-3 NUT**



**SECTION D-D**



- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
  - 2) HEAT TREAT: 40-45 Rc
  - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) REMOVE ALL SHARP EDGES, BURRS, AND WELD SPATTERS IF APPLICABLE
  - 7) IDENTIFICATION: N/A

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	JFC	<b>RBW6420G02232-8G</b>	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DATE	5/1/2019	T/R SPIDER AND SLIDER REACTION TOOL	NTS 
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